

**NEW APPLICATION COVER PAGE**

The present application is a Continuation-In-Part of U.S. Application Serial No. 09/680,644, filed October 6, 2000, which is incorporated herein in its entirety by reference.

**TITLE:** LINEAR LOW DENSITY POLYETHYLENES WITH HIGH  
MELT STRENGTH AND HIGH MELT INDEX RATIO

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**LINEAR LOW DENSITY POLYETHYLENES WITH HIGH MELT STRENGTH AND HIGH MELT INDEX RATIO**

**CROSS-REFERENCE TO RELATED APPLICATIONS**

5 [001] The present is a Continuation-In-Part of U.S. Application Serial No. 09/680,644, filed October 6, 2000, 1998, which is incorporated herein in its entirety by reference.

**FIELD OF THE INVENTION**

[002] Embodiments of the present invention relate generally to linear low density polyethylenes having a high melt index (MI), high melt index ratio (MIR) and a high melt strength (MS). These polyethylenes may be produced in a gas phase process utilizing a blend of supported metallocene catalysts.

**BACKGROUND OF THE INVENTION**

15 [003] Since the advent of Linear Low Density Polyethylene (LLDPE), these linear polymers have benefited their users with physical and mechanical properties suitable for applications such as molded parts, foams, and films.

[004] All conventional linear polymers have drawbacks that in melt processing, especially for film production, can hamper their utilization. These drawbacks are: (1) general lack of melt strength, which may manifest itself in bubble instability during film blowing process or in surging and edge weave in cast films; and (2) a low or flat response of viscosity to shear; this latter may manifest itself in higher melt viscosity leading to undesirable higher motor loads and torque requirements for extruders.

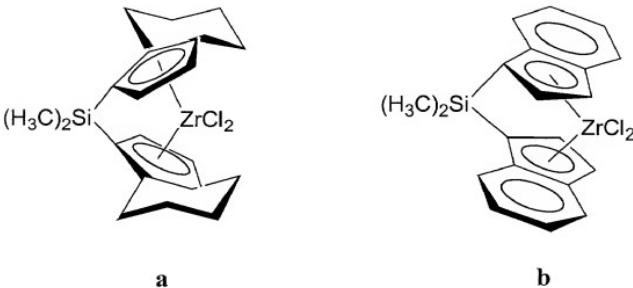
25 [005] To mitigate these drawbacks, processors have for decades, resorted to blending in branched polymers such as conventional, high-pressure process produced low density polyethylene (LDPE), into the LLDPE. However, such post-reactor additions can add to the cost as well as diminish some of the very desirable physical property improvements associated with LLDPE such as its toughness properties.

30 [006] There is a commercial need therefore for a LLDPE that will have improved melt strength and improved shear thinning in response to applied shear while maintaining the important physical and mechanical properties.

[007] We have discovered that a substantially non-blended LLDPE having relatively narrow molecular weight distribution, can have high melt strength, generally conferring good bubble stability during the melt processing of these polyethylenes in blown film

processes, high melt index (MI), and high MIR, generally indicative of a relatively high degree of shear thinning, both parameters indicating directionally improved processability.

[008] This substantially non-blended LLDPE may be made by a gas phase polymerization of ethylene and an  $\alpha$ -olefin. The polymerization may be catalyzed by a supported 5 metallocene catalyst combination. The supported catalyst will include metallocenes according to the following structures:



10 The indenyl or the tetrahydroindenyl (THI) rings may be substituted. The substituents may be linear or branched alkyl groups one to twenty carbons long, siloxy and its derivatives, phenyl and its derivatives, or any substituents group that gives an active catalyst system.

[009] The two metallocene components may be placed on separate supports and 15 separately injected into the reactor or, alternately, they may be "co-fed" (that is, the two separately supported metallocene components are introduced into the reactor(s) as a mixture or blend) or the two metallocene components may be "co-deposited" (that is, formed by each being placed on the same support). The support materials are inorganic silicas and inorganic oxide materials, which include those of Groups 2, 3, 4, 5, 13 or 14 20 metal oxides. In another embodiment, the catalyst support materials include silica, alumina, silica-alumina, and mixtures thereof. The carrier of the catalyst of this invention has a surface area in the range of from 10 - 700  $m^2/g$ , pore volume in the range of from 0.1 - 4.0  $cc/g$  and average particle size in the range of from 10-500  $\mu m$ . Other embodiments of our invention include the ratio of the two metallocenes **a:b** in the range of from 90:10 – 10:90

in a polymerization process. The catalyst system may be activated by any means known by those of skill in the art, such as by utilizing methylalumoxanes, aluminum alkyls, and mixtures thereof, non-coordinating anions, or mixed activators.

5    **Brief Description of the Drawings**

[010] Figure 1 shows GPC/DRI/MALLS of a polyethylene produced using mixed metallocene of embodiments of our invention, is compared with that of a or b alone, both relative to a linear standard, ECD-103 (available from ExxonMobil Chemical Co, Houston, TX).

[011] Figure 2 is a plot of melt strength as a function of MI for mixed metallocenes a) + b).

[012] Figure 3 is a plot of melt strength as a function of MIR for mixed metallocenes a) + b).

15    **DETAILED DESCRIPTION OF THE INVENTION**

**Zirconocenes**

[013] A broad range of zirconocenes is contemplated. Zirconocene **a** is a bridged metallocene having tetrahydroindenyl (THI) ligand system. Zirconocene **b** is similar to **a** except for the ligand system which consists of an indenyl ring system. Each or both metallocene component may be substituted. The substituents may independently be linear or branched alkyl groups from one to twenty carbons long, silicon-containing groups, halogenated hydrocarbyl substituents, phenyl and its derivatives, or any group containing nitrogen, phosphorous, boron, sulfur that produce an active catalyst system. Embodiments 20 of our invention include a mixture of dimethylsilyl bis(tetrahydro-1-indenyl)zirconium dichloride and rac-dimethylsilyl bis(1-indenyl) zirconium dichloride.

25    **Supports**

[014] The zirconocenes are placed on a support. Supports may be organic or inorganic.

[015] Organic supports may be finely divided polymer particles, polyethylene and/or 30 polystyrene, alternatively resinous support materials such as polystyrene or polystyrene divinyl benzene copolymers or polymeric compounds or mixtures thereof.

[016] Inorganic support may be one or more of silica, clays, or combinations thereof. For purposes of this patent specification the terms "carrier" or "support" are interchangeable and can be any support material, a porous support material, such as for example, talc, inorganic

oxides, inorganic chlorides, for example magnesium chloride, and resinous support materials such as polystyrene or polystyrene divinyl benzene copolymers or polymeric compounds or any other organic or inorganic support material and the like, or mixtures thereof.

5 [017] The support materials may be inorganic oxide materials, which include those of Groups 2, 3, 4, 5, 13 or 14 metal oxides. The catalyst support materials include silica, silicates (including zeolites), alumina, composite oxides, and mixtures thereof. Other inorganic oxides that may be employed either alone or in combination with the silica, include alumina or silica-alumina and magnesia, titania, zirconia, and the like.

10 [018] The carrier of the catalyst of this invention has a surface area in the range of from 10 - 700 m<sup>2</sup>/g, pore volume in the range of from 0.1 - 4.0 cc/g and average particle size in the range of from 10-500 µm. The surface area is in the range of from 50-500 m<sup>2</sup>/g, pore volume of from 0.5-3.5 cc/g and average particle size of from 20-200 µm. The surface area range is from 100-400 m<sup>2</sup>/g, pore volume from 0.8 - 3.0 cc/g and average particle size is from 20-100 µm. The average pore size of the carrier of the invention typically has pore size in the range of from 10 - 1000 Å, or 50 - 500 Å, or 75 - 350 Å.

15 [019] The zirconocenes may be both placed on a single support (co-deposited), or each zirconocene is separately placed on different support particles in two different operations. Support particles may have the same composition and particle size distribution or, alternately, they may have different compositions and/or particle size distributions.

20 [020] Separately supported a) and b) can be mixed (for example, by using a mixing device) prior to injection into the reactor ("premixed") or, alternately, they may be separately injected and mixed after entry into the reactor, or both techniques may be used. In an alternative embodiment, the catalysts, in an unsupported mode, may be mixed then atomized into a reactor, or they may be separately atomized into a reactor.

### Mixtures

[021] The ratio of a) to b) may be from 90:10 – 10:90; or 80:20 – 20:80; or 75:25 – 25:75; or 60:40 – 40:60; or 50:50.

30 [022] For purposes of this patent specification and appended claims, the terms "cocatalysts" and "activators" are used interchangeably and are defined to be any compound or component which can activate a metallocene compound as defined above, for example, a Lewis acid or a non-coordinating ionic activator or ionizing activator or any other compound that can convert a neutral metallocene catalyst component to an active metallocene cation. It is within the scope of this invention to use alumoxane as an

activator, and/or to also use ionizing activators, neutral or ionic, such as tri(n-butyl)ammonium tetrakis(pentafluorophenyl) boron.

[023] There are a variety of methods for preparing alumoxane and modified alumoxanes, non-limiting examples of which are described in U.S. Patent Nos. 4,665,208; 4,952,540;

5 5,091,352; 5,206,199; 5,204,419; 4,874,734; 4,924,018; 4,908,463; 4,968,827; 5,308,815; 5,329,032; 5,248,801; 5,235,081; 5,157,137; 5,103,031; 5,391,793; 5,391,529 and EP-A-0 561 476; EP-B1-0 279 586; EP-A-0 594-218 and WO 94/10180, all of which are fully incorporated herein by reference.

[024] Ionizing compounds may contain an active proton, or some other cation associated with but not coordinated or only loosely coordinated to the remaining ion of the ionizing compound. Such compounds and the like are described in EP-A-0 570 982, EP-A-0 520 732, EP-A-0 495 375, EP-A-0 426 637, EP-A-0 500 944, EP-A-0 277 003 and EP-A-0 277 004, and U.S. Patent Nos. 5,153,157, 5,198,401, 5,066,741, 5,206,197, 5,241,025, 5,387,568 and 5,384,299 and U.S. Patent Application Serial No. 08/285,380, filed August 10 15, 1994 all incorporated herein by reference. Combinations of activators are also contemplated by the invention, for example, WO 94/07928 and WO 95/14044 and U.S. Patent Nos. 5,153,157 and 5,453,410 all of which are incorporated herein by reference.

### **Monomers**

[025] In one embodiment, the invention is directed toward a polymerization process involving the polymerization of one or more of the monomer(s) including ethylene alone or in combination with one or more linear or branched monomer(s) having from 3 to 30 carbon atoms, or 3 to 12 carbon atoms, or 4 to 8 carbon atoms. The process is particularly well suited to the copolymerization reactions involving the polymerization of ethylene in combination with one or more of the monomers, for example alpha-olefin monomers of propylene, butene-1, pentene-1, 3- or 4-methylpentene-1, hexene-1, octene-1, decene-1, styrene and unsubstituted or substituted cyclic and polycyclic olefins such as cyclopentene, norbornenes and cyclohexene or a combination thereof. Other monomers for use with ethylene can include diolefins such as 1,4-hexadiene, 1,5-hexadiene, 1,7-octadiene, 1,9-decadiene, norbornadiene, and other unsaturated monomers. Higher alpha-olefins and polyenes or macromers (that is, reactive macro-monomers having vinyl terminated end chains) can be used also. The comonomer may be an alpha-olefin having from 3 to 15 carbon atoms, or 4 to 12 carbon atoms or 4 to 10 carbon atoms.

[026] In another embodiment ethylene is polymerized with at least two different comonomers to form a terpolymers and the like, the comonomers may be a combination of monomers, alpha-olefin monomers having 3 to 10 carbon atoms, or 3 to 8 carbon atoms, optionally with at least one diene monomer. The terpolymers include the combinations  
5 such as ethylene/butene-1/hexene-1, ethylene/propylene/butene-1, ethylene/propylene/hexene-1, ethylene/propylene/cyclic diolefins, including, but not limited to ethylene/propylene/norbornadiene, ethylene/propylene/1,9-decadiene and the like.

### Polyethylenes

10 [027] The polyethylenes that may be produced from the mixed metallocenes discussed above have surprising and unexpected properties. These properties are more surprising when the two metallocenes are separately supported then mixed prior to catalyzing the reaction between ethylene and one or more  $\alpha$ -olefins. These properties are even more surprising when the two metallocenes are codeposited onto a support prior to catalyzing the  
15 reaction between ethylene and one or more  $\alpha$ -olefins. Among the surprising properties are melt strength and MIR.

[028] Catalyst component **a**), when activated with MAO in a gas phase reaction, delivers a melt strength/MIR balance of 4.2 cN/47 for a polymer having melt index (MI) of 0.58. Catalyst component **b**), when activated with MAO under the same polymerization  
20 condition, delivers a melt strength/MIR balance of 10.2 cN/115 for a polymer having MI of 0.25 (see Table 3).

[029] For a 50/50 co-deposited catalyst system (both **a**) and **b**) on the same support) the melt strength was 11.6 cN. See Table 2, Run # 014. However, as can be seen from the data in Table 2, the melt strength of a 50/50 catalyst mixture, separately supported **a**) and **b**) on  
25 different support particles, is over 18 cN, greater than expected from a linear combination of the two melt strengths. This enhancement is even more surprising when one considers the fact that the MI of the polymer using the latter technique was in the 1.07-1.50 range, much higher than the MI of the individual polymers. Generally, the higher the MI the lower the melt strength. The MIR of the sample was measured to be 74.4.

30 [030] Since LDPEs ("low density polyethylenes", for example, high pressure free-radical initiated long chain branched polyethylene homopolymer and ethylene/vinyl acetate copolymer) are typically blended with LLDPE to improve melt strength and viscosity response to shear (where the latter parameter is described by MIR), these blends are most

often in the 10-40% range of LDPE inclusion, more likely 20-30%. The LLDPEs of embodiments of our invention are substantially non-blended.

[031] By "substantially non-blended" or "substantially unblended", we intend that the LLDPEs of embodiments of our invention have less than 10 weight percent, or less than 5 weight percent, or less than 3 weight percent, or 0 weight percent of a separate, branched polymer, for example, LDPE.

[032] Usual processing aids and other additives are not included in this discussion of blend components. Such aids and additives include, but are not limited to anti-oxidants, anti-ozanants, processing aids, slip, anti-block, anti-fog, anti-stat, colorants and the like.

10 [033] The densities of the LLDPEs of embodiments of our invention will be 0.910 – 0.965 g/cm<sup>3</sup> or 0.915 – 0.960 g/cm<sup>3</sup>, or 0.915 – 0.950 g/cm<sup>3</sup>, or 0.915 – 0.940 g/cm<sup>3</sup>, or 0.915 – 0.930 g/cm<sup>3</sup>.

[034] The melt indices of the LLDPEs of embodiments of our invention, as measured by ASTM D-1238 Condition E, will be in the range of from 0.15-15 dg/min, or 0.1-10 dg/min, or 0.1-5 dg/min, or 0.1-3 g/10 min.

15 [035] The melt index ratios (MIR,  $I_2/I_1$ ), as defined by ASTM D-1238 Condition E will be in the range from 30-120, or 40-120, or 40-100, or 45-100, or 50-90, or 50-85, or 50-75. MIR in these ranges approximates that of film extrusion grade LDPE, and is indicative of viscosity reduction in response to shear. LLDPEs generally have a nearly flat or are unresponsive to shear in their viscosity. Due to a resistance to "shear thinning," LLDPEs are typically more difficult to process which is generally manifested as a higher more power requirement during melt extrusion.

20 [036] The melt strength of polymers of embodiments of our invention, as measured by the method described in the Experimental section, will be in the range of from 5-20, or 6-20, or 7-20, or 8-20, or 10-20 centiNewtons (cN). Again this range is descriptive of LDPE melt strength.

25 [037] The composition distribution breadth index (CDBI) of the LLDPEs of embodiments of our invention will be in the range of 60-80% or 60-78%. Measurement of CDBI is determined by the technique known as temperature rising elution fractionation (TREF) for isolating individual fractions of a copolymer sample. The technique is described in J. Poly. Sci. Phys. Ed., Vol. 20, Pg. 441 (1982) and U.S. Patent 5,008,204, both incorporated herein by reference. The CDBI should be >40 %, or >50 %, or >60 %.

[038] The molecular weight distribution (MWD), or polydispersity index (PDI) also characterized by  $M_w/M_n$ , of the LLDPEs of embodiments of our invention will be generally  $\leq 4.5$ , or  $\leq 3.5$ , or  $\leq 2.5$ .

[039] We believe that LLDPEs of embodiments of our invention will find application in films, molded articles such as packaging lids, thermoformed or foamed objects and the like.

**Branching**

[040] For the purposes of this invention, the amount of branching is determined using the weight average branching index  $g$  of the branched polyethylene. The branching index  $g$  is defined as:

$$g = [Rg]_{br}^2/[Rg]_{lin}^2$$

[041] "Rg" stands for Radius of Gyration, and is measured using Multi-Angle Laser Light Scattering (MALLS) equipment. "[Rg]<sub>br</sub>" is the Radius of Gyration for the branched polymer sample and "[Rg]<sub>lin</sub>" is the Radius of Gyration for a linear polymer sample. It is well known in the art that as the  $g$  value decreases, branchiness increases.

[042] Long chain branching is inferred when the polymer radius of gyration deviates from that measured for a linear polymer. The average deviation level was calculated from gel permeation chromatography (GPC)/DRI/MALLS data using the procedure outlined below (DRI stands for Differential Refractive index detector, which detects mass of polymer passing through the GPC column). First, the GPC/DRI/MALLS data was used to obtain molecular weight averages ( $M_w/M_z$ ) and polymer radius of gyration that gives absolute molecular weight. For polyethylene polymers, the MALLS measurement of Rg is particularly sensitive in the range from 100,000 gram/mole to about 2,000,000 gram/mole. For this reason, the data was then truncated outside this range.

[043] The GPC/DRI/MALLS of a polyethylene produced using the mixed metallocene of embodiments of our invention, is compared with that of **a** or **b** alone, both relative to a linear standard, ECD-103 (available from ExxonMobil Chemical Co, Houston, TX). This is shown in Figure 1. The dotted line on the top of each graph represents the theoretical  $g$  for a perfectly linear polymer. Any deviation from this line indicates branching, which typically increases with increasing molecular weight. In these examples, **a**) alone shows slight deviation from the  $g = 1.0$  reference line, whereas **b**) alone and (**a + b** mixed) show

large deviations from the reference line. The weight-average,  $\langle g \rangle_w$ , and z-average,  $\langle g \rangle_z$ , g-values are shown in the table below. The surprising observation is that the g values seen in (**a + b** mixed) case is about 30 % more than one would expect from a simple additive effect.

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	$\langle g \rangle_w$	$\langle g \rangle_z$
<b>a</b> alone	0.96	0.942
<b>b</b> alone	0.566	0.44
( <b>a + b</b> ) mixed	0.687	0.652

[044] Also in Figure 1 are shown the variations in the Radii of Gyration for the three cases. The straight line drawn from the left bottom corner to the right top corner represents the Radius of gyration for an ideal linear chain. Any deviation from it indicates branching. The polymer produced from **a)** alone shows a slight but noticeable deviation from the linear standard, whereas the other two cases show large deviations. The surprising observation is that the Radius of Gyration pattern seen in (**a + b**) mixed) case is quite similar to the case of **b)** alone, despite the fact that the mixed catalyst contains only half as much the **b)** component. The separately-supported mixed metallocene catalyst polymer shows much stronger deviation from the linear standard, indicating enrichment of the polymer with about twice as much branched species relative to **a)** or **b)** alone. The exact nature of these branched species at the high molecular weight tails, is not well known.

[045] Figure 2 is a plot of melt strength as a function of MI for mixed metallocenes **a) + b)**. There are two sets of points in the mixed metallocene line: one is for (**a + b**) blend, which is in the range of 1-2 MI, the other is for (**a + b**) codeposited and is in the 2-5 MI range. For comparison, LDPE and linear LLDPE lines are also shown along with the performance of a blend of LLDPE and combs (statistical). The comb blends were described in WO 98/34985 (US Patent No. 6,114,475).

[046] Figure 3 is similar to Figure 2 except that the MI axis is replaced by MIR. The rectangular box represents typical LDPE polymer range and is intended for comparison purposes only. Notice that the (**a + b**) blend gives much higher MIR/melt-strength response than the (**a + b**) codeposited case.

## **Experimental**

### Laboratory Gas Phase Reactor:

[047] The polymers of embodiments were made in laboratory runs of gas phase ethylene and ethylene/butene utilizing a two-liter autoclave reactor, equipped with an anchor impeller and jacketed heating. Sodium chloride was used as a fluidized bed in the reactor and was removed by dissolution and often with subsequent reprecipitation of the polymer. The salt was prepared by dehydration at 450°C under nitrogen over several days. The reactor pressure was read in gauge pressure, rather than absolute, and was measured using a 5 Sensotech pressure transducer.

### Preparation of Supported Mixed Catalyst:

[048] Metallocenes were pre-contacted with methylalumoxane and supported on silica using a preparation method described in US Patent 5,863,853, incorporated herein by reference. The preparation was calculated such that the catalyst was deposited onto the support using just enough solvent to fill the support pores. By using this minimum wetting, drying times and the amount of solvent required were both reduced. The metallocene and methylalumoxane (MAO) were pre-contacted in toluene prior to introduction of the silica support material and mixing. Solvent removal by vacuum was continued to constant dryness (until no further weight loss occurred).  
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### **Supported Catalyst Preparation Example:**

[049] Materials: Silica: MS948m, 1.6 mL/g pore volume, W. R. Grace, Davison Chemical Division, Baltimore, Maryland (Davison Chemical Co.) previously heated to 600°C under nitrogen. Dimethylsilylbis(tetrahydro-1-indenyl) zirconium dichloride was used as supplied by Albemarle, and rac-dimethylsilylbis(1-indenyl)zirconium dichloride as supplied by Boulder Scientific Corporation (BSC). Methylalumoxane as a thirty weight percent clear MAO solution in toluene was supplied by Ethyl Corporation, Baton Rouge, Louisiana.  
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[050] Dimethylsilylbis(tetrahydro-1-indenyl) zirconium dichloride(0.001 moles, formula weight (FW) 456.57, 0.45 g), and rac-dimethylsilylbis(1-indenyl)zirconium dichloride (BSC-326, 0.448 g, FW 448.57 g, 0.001 moles), totaling 0.90 g, 0.002 moles, for 0.18 g Zr; plus 38.7 g MAO (30% in toluene, which represents 11.6 g MAO at 58 g/mole, and 5.4 g A1), and 41.6 g of dry toluene were used for a typical preparation. The zirconium catalysts

at various weight/weight ratios were simultaneously dissolved in toluene, and then pre-contacted with MAO and let sit for 30 minutes to activate. 30 g silica were added and blended with a spatula. The solvent was evaporated *in vacuo*, and after reaching constant weight, a dry free-flowing supported catalyst powder was isolated.

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Polymerization:

[051] Polymerization runs were performed in the above-described 2-liter autoclave reactor equipped with an anchor impeller, an external water jacket for temperature control, a regulated supply of dry nitrogen, ethylene or ethylene/butene mixture, and reactor ports for introduction of seed bed, scavenger, other comonomers, hydrogen, and supported catalyst. The reactor was dried and degassed at 140°C under nitrogen for a minimum of one hour prior to use. A typical run consisted of introducing 200g of dried sodium chloride and 0.2 mL of triethylaluminum (TEAL, 25 mole% in heptane) to the reactor and heating the reactor to 100°C. The reactor was then vented and 0.8 psi of nitrogen purged through.

10 After 5 minutes, the nitrogen and the reactor outlet were sealed off and the supported catalyst, 500 mg as prepared below, was pressured into the reactor under nitrogen. Then 40 psig of ethylene was pressured throughout the run. The polymerization reaction was limited to 60 minutes. Venting and rapid cooling of the system quenches the reaction. The catalyst was killed by air exposure and the reactor contents were poured into distilled water

15 to dissolve the seedbed. Polyethylene was recovered by filtration and rinsed by passing toluene, hexane and methanol at ambient temperature through a Buchner funnel containing the polymer.

20

Gas Phase Copolymerizations:

[052] The polymers of the invention were prepared in gas phase polymerization under standard conditions. Catalyst activity was defined as kilograms polymer produced (dry yield of isolated polymer product) per mole zirconocene per hour. Laboratory catalyst activity was expected to be lower than pilot scale measured activities, or productivities, due to thermodynamics of scale and the improvement in surface to volume ratio on the larger scale. Molecular weight behavior was important for the definition of a catalyst and process for film-forming polyethylenes. First, the polymer must be of a reasonable molecular weight to process easily into films, and second, the long chain branching known to improve processability may be decreased for a given catalyst system in the presence of hydrogen.

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30

Therefore, a system requiring minimal hydrogen to achieve molecular weights suitable for film applications may be desirable. The process conditions, as developed in earlier work, were run at commercially viable temperature and pressure.

Table 1: CATALYST COMPARISONS FOR LCB PE<sup>1</sup>:

5 LABORATORY GAS PHASE REACTOR AT 85°C AND 100 PSI

Metallocene	Run	Monomer(s)	Mw, k	MWD	Activity	Pseudo
	Number					R1
b)	7-080	C <sub>2</sub>	143	4.5	1434	
	8-079	C <sub>2</sub> /C <sub>4</sub>	104	6.1	2087 <sup>2</sup>	0.75
a)	11-115	C <sub>2</sub>	57	3.8	1305	
	12 126	C <sub>2</sub> /C <sub>4</sub>	93	5.9	471	1.93

<sup>1</sup> Summary of Best Results over approximately 35 runs.

<sup>2</sup> Catalyst b) showed the highest activities for copolymerization.

- 10 [053] Melt strength (MS) was measured using a Goettfert Rheotens attached to an Instron capillary rheometer. For this test, polymer melt is extruded through a capillary with a radius of 0.007633 cm and an aspect ratio (capillary length/capillary radius) of 33.531 at a constant plunger velocity. Therefore, the polymer melt is subjected to a constant apparent wall shear rate. The extruded melt is subsequently stretched by a pair of serrated wheels having radii of 1.91 cm at a distance (H) from the capillary exit. The rotational speed of the wheels is increased linearly with time while the draw down force (F) is monitored. Melt strength is reported as the draw down force (cN) when the strand breaks. The following conditions were used in the melt strength measurements: temperature = 190°C; plunger speed = 0.127 cm/s; wheel acceleration = 2.4 cm/s/s; capillary radius = 0.076327 cm; capillary length = 2.5593 cm; barrel radius = 0.47625; and wheel radius = 1.91 cm.
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Table 2: Supported MAO-Activated Gas Phase Catalyst Laboratory Runs<sup>†</sup>

Run#	Catalyst Amount, mg.	Temp. °C	Psi, Ethylene	Yield, grams	Act. kgP/molM	NMR, wt%/ $m^2\%$ butene	MI g/10min	MS, cN	Mn X1000	Mw X1000
014	500 codeposited	85	120 <sup>‡</sup>	23	980	7.8/4.0	NA	NA	11.6	21
029	1000 codeposited	80	100 <sup>‡</sup>	35	750	8.5/4.5	2.9	38.9	9.5	17
013	1000 codeposited	85	100 <sup>‡</sup>	52	1140	8.7/4.5	4.0	35.5	8.6	17
034	1000 codeposited	90	100 <sup>‡</sup>	18	410	8.0/4.2	NA	NA	10.8	13
102	500+500 blend	85	100	61	1326	NA	1.1	74.4	17.0	98
103	500+500 blend	85	100	64	1401	NA	1.2	52.0	14.0	89
104	500+500 blend	85	100	59	1297	NA	1.5	50.5	14.5	80
106	500+500 blend	85	100	34	740	9.3/4.9	NA	NA	18.1	70
107	250a+750b blend	85	100	44	960	9.2/4.8	NA	NA	6.3	15
113	750a+250b blend	85	100	45	990	NA	1.9	53.3	7.7	69
117	1000 codeposited	85	120	94	NA	NA	4.0	37.4	6.0	NA
120	1000 codeposited	90	100	33	NA	NA	2.6	35.2	11.0	NA
122	1000 codeposited	85	100	79	NA	NA	5.4	34.1	4.0	NA
NA = not available										

<sup>†</sup>a + b supported as given in the experimental section, unless otherwise noted.<sup>‡</sup>Ethylene gas purchased as a 95.5 mole percent ethylene-butene mix at 200 psi, for semi-continuous gas phase feed.

**Table 3: PILOT PLANT RUNS**

Metallocene	<b>a</b> alone	<b>b</b> alone	<b>a + b</b> codeposited
Melt Index	0.58	0.25	0.73
MIR	47	115	61
MS cN	4.2	10.2	7.8
MWD	3.6	3.8	3.7

Although the present invention has been described in considerable detail with reference to certain versions thereof, other versions are possible. For example, while metallocene catalysts are exemplified, any catalyst or catalyst system that produces polymers having a relatively high MIR and a relatively high melt strength are also contemplated.